

Work Order ID 127653

127653

Page 1

December-17-14 1:42:09 PM

Item ID: D206-802-033

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Baggage Door Opener Aluminum Door

Stop

NS2

Start Date: 12/10/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-12-23 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-2	A								
IIN-D407-802-3	A								

100

Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D206-802-033 CHG002

18

DAS
46
9-83

FEB 19 2015

105

Pick Kit

0.00

105

Packaging

Packaging

Memo

0.00

DAS
27
9-83

DAS
27
9-83

FEB 18 2015

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127653

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Item ID: D206-802-033 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Baggage Door Opener Aluminum Door
 Start Date: 12/10/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				(1x)	DAS 45 J-53		FEB 19 2015
120 *120* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPDD206-802-033 Location: _____ PPP rev: _____	0.00 0.00		Ship				DAS 06 9-89	FEB 19 2015
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							15/2/19 MF 15-2-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127653

127653

Parent Item: D206-802-033

D206-802-033

Parent Item Name: Baggage Door Opener Aluminum Door

Start Date: 12/10/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-19 *D3552-19* Door Prop		Manufactured	No			105	Each	1.0000	1	1		DAS 27 9-89 FEB 18 2015	
	DAS 45 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST364				1					
				88102				1					
D4109-043 *D4109-043* Doubler Assembly		Manufactured	No			105	Each	3.0000	1	1		DAS 27 9-89 FEB 18 2015	
	DAS 45 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				3					
				H04229				3					
D4113-041 *D4113-041* Doubler Assembly, Baggage Door		Manufactured	No			105	Each	2.0000	1	1		DAS 27 9-89 FEB 18 2015	
	DAS 45 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST092				2					
				H85049				2					
80-004-2-6 *80-004-2-6* Insert		Purchased	No			105	Each	1,665.000	4	4		DAS 27 9-89 FEB 18 2015	
	DAS 45 9-89												
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST563				1665					
				124720				1552					
				124747				3					
				m125841				110					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

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Work Order ID: 127653

127653

Parent Item: D206-802-033

D206-802-033

Parent Item Name: Baggage Door Opener Aluminum Door

Start Date: 12/10/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

CR3213-4-2

Purchased

No

105

Each

100.0000

8 8

DAS

27

9-89

CR3213-4-2

Cherry Rivet

DAS

46

9-89

Location

ST319

Loc Qty

100

100

Loc Code

**

FEB 18 2015

MS27039C1-06

Purchased

No

105

Each

193.0000

4 4

DAS

27

9-89

MS27039C1-06

Screw (601.2459)

DAS

46

9-89

Location

ST283

Loc Qty

193

193

Loc Code

**

FEB 18 2015

NAS1149C0363R

Purchased

No

105

Each

1,076.000

4 4

DAS

27

9-89

NAS1149C0363R

Washer

DAS

46

9-89

Location

FP001

Loc Qty

261

261

Loc Code

114742

ST271

815

815

gm130673

**

FEB 18 2015

DQA: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

REFERENCE ONLY

FEB 19 2015

DART AEROSPACE LTD.

DAS

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IIN-D206-802-3

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5.3 D206-802-033 Baggage Door Opener Kit, Metal

Qty -033	Part Number	Description
☒	D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
☐		
1	D3552-19	DOOR PROP
1	D4109-043	DOUBLER ASSEMBLY
1	D4113-041	DOUBLER ASSEMBLY, BAGGAGE DOOR
4	80-004-2-6	INSERT
8	CR3213-4-2	RIVET
4	MS27039C1-06	SCREW
4	NAS1149C0363R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
☒	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
☐		
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT

5.5 D206-802-131/-133/-135 Combination Kits.

Qty -131	Qty -133	Qty -135	Part Number	Description
☒	☒	☒	D206-802-131	5 DOOR OPENER KIT (METAL BAGGAGE DOOR)
☒	☒	☒	D206-802-133	5 DOOR OPENER KIT (COMPOSITE BAGGAGE DOOR)
☒	☒	☒	D206-802-135	4 DOOR OPENER KIT
☐	☐	☐		
1	1	1	D206-802-029	CREW DOOR OPENER KIT, LH
1	1	1	D206-802-030	CREW DOOR OPENER KIT, RH
1	1	1	D206-802-031	PASSENGER DOOR OPENER KIT, LH
1	1	1	D206-802-032	PASSENGER DOOR OPENER KIT, RH
1			D206-802-033	BAGGAGE DOOR OPENER KIT, METAL
	1		D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE

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Revision: A

Date: 10.10.13

Work Order ID 127653

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Item ID: D206-802-033 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Baggage Door Opener Aluminum Door
 Start Date: 12/10/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-12-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-2	A								
IIN-D407-802-3	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-033 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

FEB 18 2015